

Date: Tuesday, 12/5/2006 8:15:22 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT BRACKET  
 Job Number : 29775  
 Estimate Number : 10260  
 P.O. Number : N/A Part Number : D23623  
 This Issue : 12/5/2006 S.O. No. : N/A Drawing Number : D2362 REV E1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : E1  
 Previous Run : 29436 Material : N/A  
 Due Date : 1/5/2007 Qty: 15 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]* 06/12/05  
 Comment : Est: G 0005.18 Added inspection level 8 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2265 Step Support Casting



Comment: Qty.: 1.0000 Each(s)/Unit Total: 15.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	B29079

En 06/12/28

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Machine per folio D2362-3

En 06/12/28 x 15

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: Inspect Level 2

En 06/12/28 x 15

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 06/12/28 (15)

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr

SAD 07/01/07 (15)

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

M102391  
SAJ 07/01/07 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   D   Date: 07/10/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:15:23 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 29775

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ml 07/01/10

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

B27768 (x4)

B29809 (x11)

ml

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

B27769 (x4)

B29810 (x11)

ml

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement

as per Dwg D2362

Batch M 102565

ml 07/01/10

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 07/01/10 (15)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51169

07/01/11 (15) 07/01/11 15

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/11 (15)

Job Completion



07/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 29775
<b>Description:</b> Step Support Bracket		<b>Part Number:</b> D2362-3
<b>Inspection Dwg:</b> D2362	<b>Rev:</b> E1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	0.260	✓			
3.074	+/-0.010	3.071	✓			
0.34	+/-0.030	0.329	✓			
0.77	+/-0.030	0.759	✓			
1.500	+/-0.010	1.501	✓			
1.000	+/-0.010	1.010	✓			
0.80	+/-0.030	0.789	✓			
1.200	+/-0.010	1.210	✓			
1.28	+/-0.030	1.276	✓			
1.000	+/-0.010	0.990	✓			
0.75	+/-0.030	0.759	✓			
1.88	+/-0.030	1.876	✓			

<b>Measured by:</b> En	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06/12/28	<b>Date:</b> 06/12/28	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF [Signature]	[Signature]



RELEASED  
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	CP	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 1 OF 3
		SCALE
		1:2
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

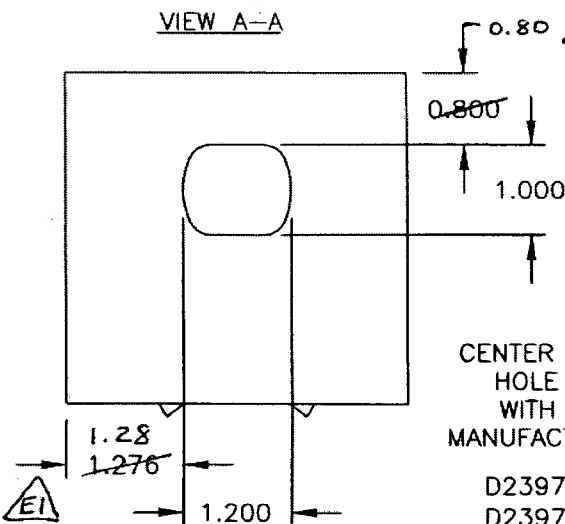
03.03.95 CP

DESIGN OK, BUT CHECK WITH  
JB BEFORE MANUFACTURE  
OK 07/11/04

0.257 X 0.75 SLOT

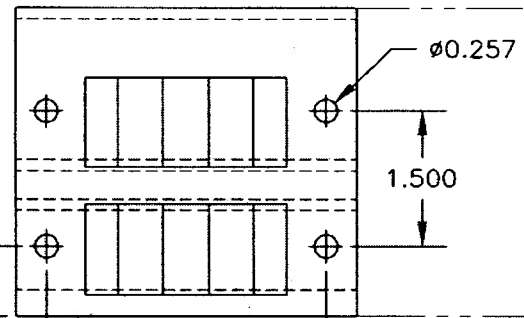
REMOVE TIPS  
FROM CASTING  
MAX 0.080

VIEW A-A



CENTER D2397-1/-3 RUBBER  
HOLE WITH SLOT AND BOND  
WITH CONTACT CEMENT PER  
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)  
D2397-3 RUBBER CUSHION (1)



D2362-3

NOTES:  
MAKE FROM D2265  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING  
RUBBER IN PLACE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

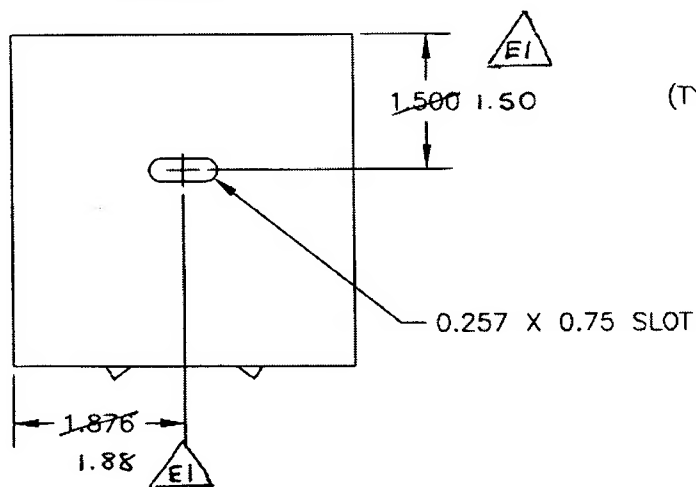
WORK ORDER  
NO. 24975  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
3.074  
SHOP COPY





DESIGN	DRAWN BY	TITLE	REV. E
BW	CP	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JH	DRAWING NO. D2362	SHEET 2 OF 3
DATE 98.12.04		STEP SUPPORT BRACKET	SCALE 1:2

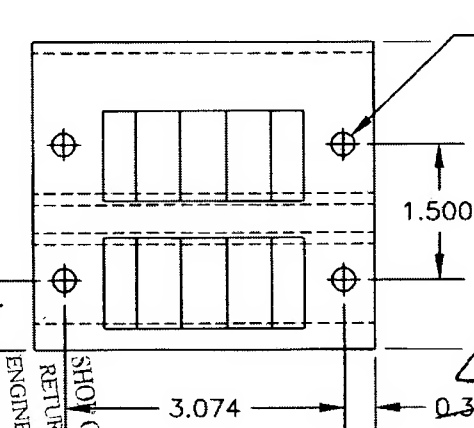
VIEW A-A



MACHINE TO  
R1.100  
(TYP 2 PLACES)

REMOVE TIPS  
FROM CASTING  
MAX 0.080

0.257 X 0.75 SLOT



Ø0.257

0.100

R16.680

BLACK ANTI-SKID PAINT FOR D2362-1  
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

RELEASED  
98.12.14  
UNDER REVIEW

DESIGNED BY  
D2362-1 & D2362-5  
D2362-1 & D2362-5  
D2362-1 & D2362-5

OK  
98.12.04

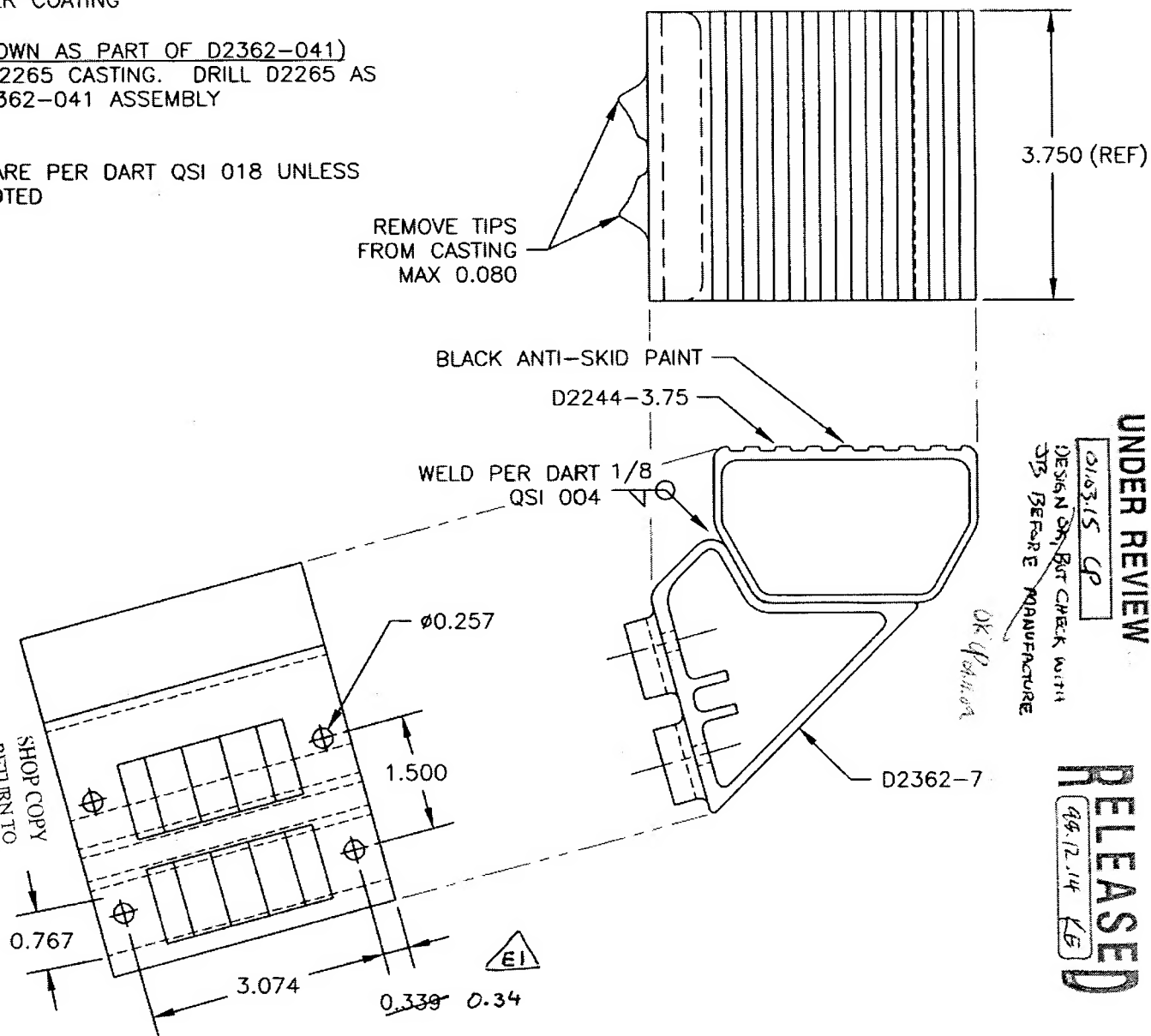
NOTES:  
1. MAKE FROM D2265  
2. BLACK ANTI-SKID PAINT PER DART QSI 005 4.4  
3. D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION  
4. FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3  
5. BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5  
6. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
RETURN TO  
ENGINEERING  
WITHOUT NOTICE  
WORK ORDER  
NO. 29795

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)  
MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



## UNDER REVIEW

44-12,14 KE

**DART**

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW	<i>CP</i>	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
<i>KE</i>	<i>HA</i>	D2362	SHEET 3 OF 3
DATE		TITLE	SCALE
98.12.04		STEP SUPPORT BRACKET	1:2